

5/13

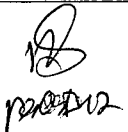



DART AEROSPACE LTD		Work Order:	22792
Description: Doubler		Part Number:	D3302-3
Dwg: D3302 Rev. <i>01.12.11</i>		Qty:	20 <i>10</i>
		Page 1 of 1	


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	<i>JA</i>	05.03.22	20 <i>10</i>
2	MV	Cut blank: 14.300" x 9.100" <i>14.550"</i> Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-3 Batch: <i>M16455</i>	<i>En</i>	05/03/23	10 <i>20</i>
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-3	<i>En</i>	05/03/23	10 <i>PTO</i>
4	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/03/23	10
5	QC8	Second check	<i>Tru</i>	05/03/23	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	<i>2</i>	05.03.24	10
7	GB	Form as per Dwg D3302	<i>2</i>	05.03.24	10
8	QC5	Inspect work to Step 7	<i>18</i>	05.03.24	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>CL</i>	05/03/24	10
10	QC3	Inspect Chemical Conversion Coat	<i>LI</i>	05.03.24	10
11	ST	Identify and Stock	<i>CL</i>	05/03/24	10
12	AC	Cost / part <i>H.57 19.29</i>	<i>Suf</i>	05.03.24	10
13	DC	Close W/O <i>H.25</i> Inspect Level 21	<i>JA</i>	05.03.24	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 04.09.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/23	# 3	first stack moved in Downs.		Swap & replace	EP 05/03/23	 05-03-23	 05-03-23	 05-03-23
05/03/23	# 3	only enough mat. to make 10 parts.						

Part No: D3302-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/03/24
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22792
Description: Doubler		Part Number:	D3302-3
Inspection Dwg: D3302	Rev: AE ^{B2} B1 ⁰¹⁻¹²⁻¹⁶	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.453	/			
14.202	+/-0.030	12.749	/			
12.750	+/-0.010	0.851	/			
0.851	+/-0.010	0.851	/			
0.851	+/-0.010	0.851	/			
9.042	+/-0.010	9.003	/			
7.34	+/-0.030	7.30	/			
5.000	+/-0.005	—	no holes			cannot measure
1.000 pitch	+/-0.005	—	no holes			cannot measure
R0.12	+/-0.030	0.12	no holes			
1.031	+/-0.010	—	no holes			cannot measure
2.021	+/-0.010	—	no hole			cannot measure
1.101	+/-0.010	—	no holes			cannot measure
11.250	+/-0.005	—	no holes			cannot measure
1.125 pitch	+/-0.005	—	no holes			cannot measure
1.476	+/-0.010	—	no holes			cannot measure
7.101	+/-0.010	—	no holes			cannot measure
0.063	+/-0.010	—	no holes			cannot measure
Ø0.098	+0.005/-0.000	—	no hole			cannot measure

Measured by: <i>EP</i>	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 05/03/23	Date: 05/03/23	Date:	N/A

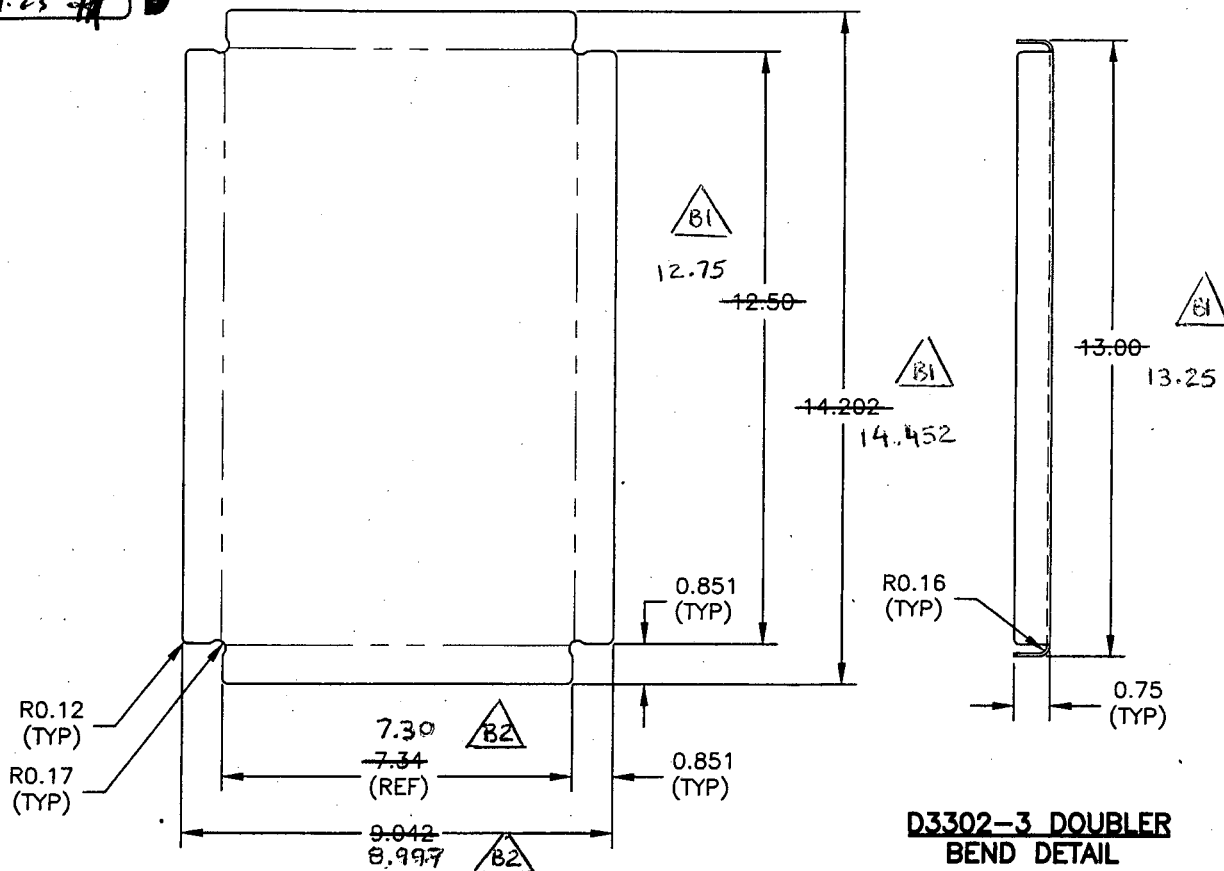
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05/04/08-07



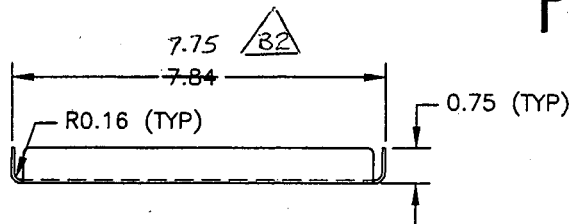
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 #



D3302-3 FLAT PATTERN

PRELIMINARY ISSUE



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

SHOP COPY
TURN TO
ENGINEERING

WORK ORDER
NO. 22792

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 21, 2005
10:23 am

Work Order No : 0022792
Project Name : D3302-3
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3302-3
Description : Doubler
Manufactured : Yes
Amount Req'd : 20/10u
Amount Done : 0
Start Date : 03-21-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00